	Work Order ID 69906 Tuesday, May 24, 2011 12:58:40 PM												Page 1
Item ID: Revision ID:	D3396-1			Accept						Setup	Start		
Item Name:	Spacer		1 19818	. (111)							Stop		
Start Date:	5/24/2011	Start Qty: 30.00				Cust Item II	D:						
Required Date	: 5/31/2011	Req'd Qty: 30.00				Customer:							
Reference:								_	,	D	C4a w4	1 (8 8) (13 1 3	
Approvals:	Process Pla	an:	Date: _//-(15-24 Toolin	g:	Da	te:			Run	Start		
	QC:		Date:	SPC (Da	te:				Stop		
Sequence ID/ Work Center I	D	Operation Description			Up/ 1 Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr											
D3396	Rev	/ B											
100 Hardinge		Hardinge CNC LATHE	E SMALL	0.00					30	4	b		
Hardinge CNC Lath	ne Small		r Folio FA514 and D	owg D3396□Deburr	2/	1116/22	,						
110 		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00					30		be _		
Quality Control						(1/6/22	7						
120		QC8- Inspect parts - se	cond check	0.00	20	11.6.2	- 2				1		

0.00

Memo

Quality Control

Dart Ae	rospace	e Ltd							₹ *
W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty o	pproval thief Eng / Prod Mgr	Approval QC inspector
		·						***************************************	
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:		Date: _	
	R	esolution:	Disposition	n:	QA: N/C C	losed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			***************************************
		Description of NC		Corrective Action Section		Verificat	tion A	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	Section .		Chief Eng	QC Inspector
,									
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	<u> </u>								:
					1				

Page 2

Tuesday, May 24, 2011 12:58:40 PM

Item ID:

D3396-1

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Spacer

5/24/2011

Start Qty: 30.00

Req'd Qty: 30.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Start

Stop



Required Date: 5/31/2011

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Run

Sequence ID/ Work Center ID

130

Packaging Packaging

Memo

Memo

Identify as per dwg & Stock Location.

Run Hours

0.00

0.00

Code

Tool # Plan Accept Qty,

Reject Réjec Number

Insp. Stamp

140

OC21- Final Inspection - Work Order Release

0.00

0.00

11-06-23

Quality Control

W/O:			WO	RK ORDER CHAN	GES				
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					· · · · · · · · · · · · · · · · · · ·			Prod Wgr	<u>'</u>
		y.					į		
•									
Part No		PAR #:							
Res		esolution:						Date: _	
NCR:		\	WORK ORDE	R NON-CONFORM	MANCE (NCI	R)			
DATE	STEP	Description of NC			ection B Sign		Verification Appr		Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Date		tion C	Chief Eng	QC Inspector
		·			•				
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						!			

Picklist Print

Tuesday, May 24, 2011 12:58:46 PM

Work Order ID: 69906

Parent Item:

D3396-1

Parent Item Name: Spacer

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 30.00

Required Qty: 30.00

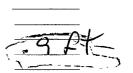
Comments:

IPP A□ 05.02.23□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Issued Issue	Status d
MDELRINR0.750		Purchased	No			100	f	73.2000	0.0625	1.973684		
										1.7	10613	د

Delrin Round Bar 0.75"

Location	Loc Oty	Loc Code
MAT055	73.2	
115472	7.5	
116183_	3.6	
117273	56	
117322	6.1	



W/O:	•		WC	RK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		ž.								
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ .	A:	_ Date: _	
	Res	solution:	Disposition	n:	QA: N	/C Clo	sed:		Date:	
NCR:			WORK ORDI	R NON-CONFORM	MANCE (I	VCR)				
DATE	STEP	Description of NC	11.1.	ection B	Verification		Approval	Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	on C	Chief Eng	QC Inspector
									_	

DART AEROSPACE LTD	Work Order:	69906
Description: Spacer	Part Number:	D3396-1
Inspection Dwg: D3396 Rev: B	· ·	Page 1 of 1

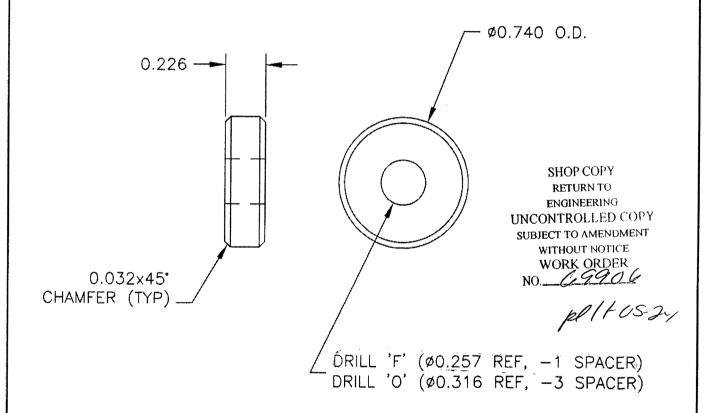
	FIRS	T ARTICLE II	NSPECTI	ON CHE	CKLIST		
		First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		mments
0.226	+/-0.010	,228			5/5	7	
Ø0.257	+0.005/-0.000	0,257				1	
Ø0.740	+/-0.010	739					
0.032 x 45°	+/-0.010	030X45					
Measured by:	The state of the s	Audited by:	 Ze		Prototype	e Approval:	N/A
Date:	106/22	Date:		-22		Date:	N/A
Rev Date A 05.04.27 B 06.03.09	Change New Issue Dwg Rev update	d				Revised by KJ/JLM KJ/JLM	Approved

W/O:			WO	RK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:	·							
		÷							
Part No		PAR #:	Fault Cate	Fault Category: NCR: Yes No					
	R	esolution:	Disposition	ı:	QA: N/C	Closed: _		Date: _	
NCR:		\	WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B		ication	Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	e Se	ction C	Chief Eng	QC Inspector
	,								
_									



DESIG	CP	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	KED fil	APPROVED ALL	DRAWING NO.	EV. B
	洲	H	D3396 SHEET 1	OF 1
DATE			TILE	SCALE
 05.0	94.27		SPACER	2:1
Α		05.03.10	NEW ISSUE	
В		05.04.27	ADD -3	





D3396-1/-3 SPACER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:			Ŵ	ORK ORDER CHANG	ES					
DATE	STEP	PROC	EDURE ÇHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<u> </u>								
		*								
Part No	:	PAR #:	Fault Cate	aorv:	NCR: Y	es No	DQ.	 A :	Date:	<u> </u>
		esolution:								
NCR:		; W	ORK ORD	ER NON-CONFORMA	ANCE (N	CR)				
DATE	STEP	Description of NC Section A	Initial	Section B on Sign & Date		Verification Section C		Approval Chief Eng	Approval QC Inspector	
			Chief Eng	Chief Eng	U	ate				
					_					